

dat *SHIP JAN 14th !!*
Work Order ID 55184 - 1

January 8, 2010 1:44:39 PM



Page 1

Item ID:	D3262-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Canister Assembly					
Start Date:	1/08/10	Start Qty:	4.00			
Required Date:	1/12/10	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	<i>N</i>	Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3262	Rev C

100	Weld per dwg. A/R Aluminum rod Batch:	0.00							
	Large Fab								
Large Fab	<i>M113207</i>								
	Memo	0.00							
Large Fab	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings								

(X1)

epc 1901/13

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	Memo	0.00							

ID 10.01.13 (1)

120	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	Memo	0.00							
	Pressure test as per Dwg D3262								

⇒ 506013

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55184

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Item ID: D3262-041	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Canister Assembly				
Start Date: 1/08/10	Start Qty: 4.00		Cust Item ID:	
Required Date: 1/12/10	Req'd Qty: 4.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	⇒ M 10-01-13			(X1)	φ		
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113170 Memo ****Ensure to mask threads **** START TIME: 7:30AM OVEN TEMPERATURE: 320°C FINISH TIME: 8:00AM	0.00 0.00	⇒ M 10-01-14			(X1)	φ		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR 10-01-14			(1)	φ		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55184

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Item ID: D3262-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Canister Assembly

Start Date: 1/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/12/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PPP
54895

0.00

Packaging

PC 10/01/14 (1)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15
MF 10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55184



Parent Item: D3262-041



Parent Item Name: Canister Assembly

Start Date: 1/08/10

Required Date: 1/12/10

Comments: IPP C 05.03.10 Removed P/O for liquid penetrant inspection KJ/JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3262-1

Manufactured

No

100

Each

6.0000

4.0000



Tube

4/40/01/11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

53504

6

D3262-3

Manufactured

No

100

Each

0.0000

8.0000



Cap

④ ex

B53503

10-1-11 EQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

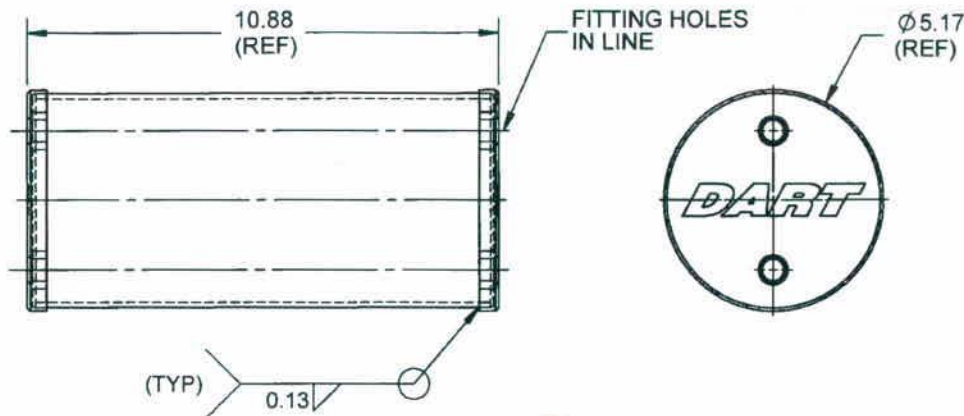
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

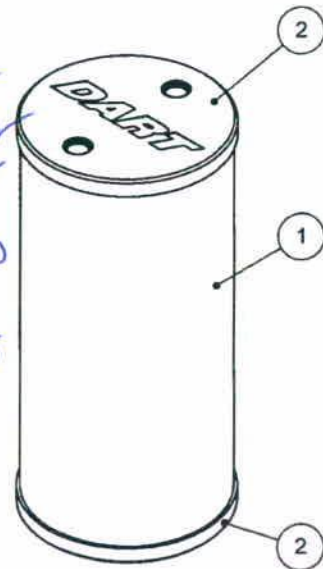
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

RELEASED06.09.19 *[Signature]***UNDER REVIEW**09/11/12 *[Signature]*
CAR 09-004**D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

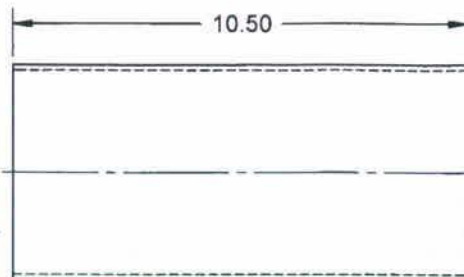
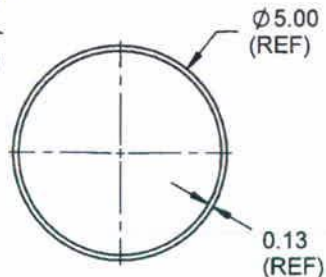


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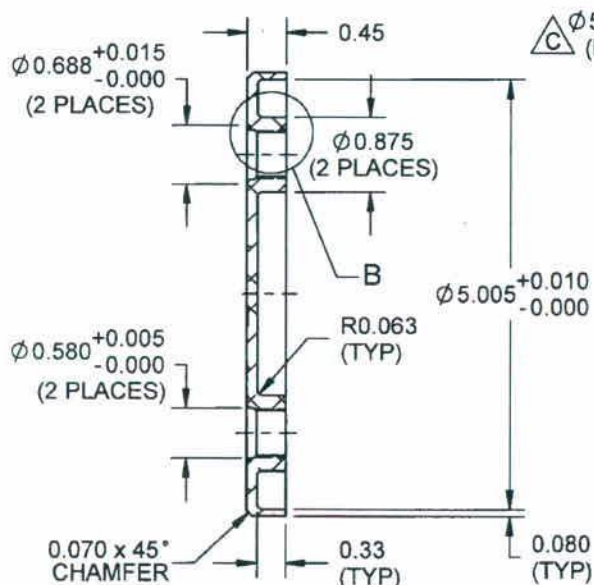
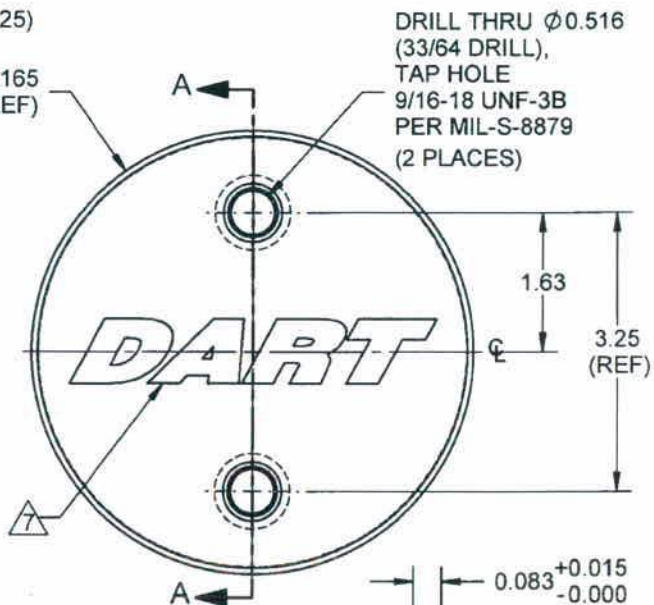
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262
DATE 06.08.31	TITLE FUEL PURGE CANISTER	REV. C SHEET 2 OF 2 SCALE 1:4

**UNDER REVIEW**
[Handwritten: by 11/12/15, CHR 29-204]**RELEASED**
*[Handwritten: 06.09.19]***D3262-1 TUBE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**
SCALE 1:2

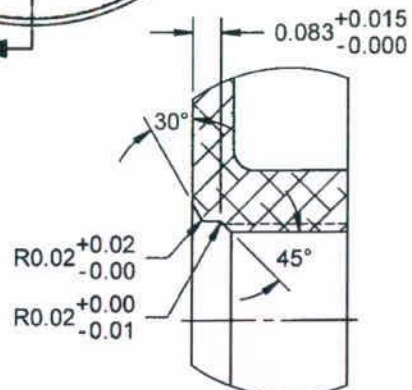
DRILL THRU $\phi 0.516$
(33/64 DRILL),
TAP HOLE
9/16-18 UNF-3B
PER MIL-S-8879
(2 PLACES)

D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

**DETAIL B**
SCALE 2:1

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L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: January 6, 2010 8:13 AM
To: 'L Lacelle'
Cc: 'Roberto Fuentes'; 'David Shepherd'
Subject: RE: canisters

Knock yourself out

(Yes....the B205 ones are ok. Just the 212/412 are the issue. Eng will sign off)

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 06, 2010 7:29 AM
To: mpetsche@dartaero.com
Cc: 'Roberto Fuentes'; 'David Shepherd'
Subject: canisters
Importance: High

We have another 205 fuel purge canister to ship next Friday, but the canisters are still under review...can we make any of these to help this customer out? Need an answer asap please

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd